

Date: Monday, 6/12/2006 3:37:09 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROCTOR AFT LH
Job Number	: 27510		
Estimate Number	: 11228		
P.O. Number	: N/A	Part Number	: D32813
This Issue	: 6/12/2006 S.O. No. : N/A	Drawing Number	: D3281 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 26355	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 6/30/2006 Qty: 20 Um: Each
Checked & Approved By	: <u>PA 06.06.13 N</u>		
Comment	: Est Rev: A 04.07.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 1493C 206/15/06 (20)

Description: Floor Protector Aft, LH

Possible Supplier: Delastek

Certificate of Conformity is required

2.0

D32813P

Floor Protector, Aft LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) ✓
 Floor Protector Aft, LH

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

PA 06/07/14(20)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

PA 06.07.13(20)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: U/Ah

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 26/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:37:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT LH

Job Number: 27510

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206.07.19

Job Completion



206.07.19

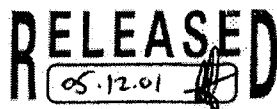
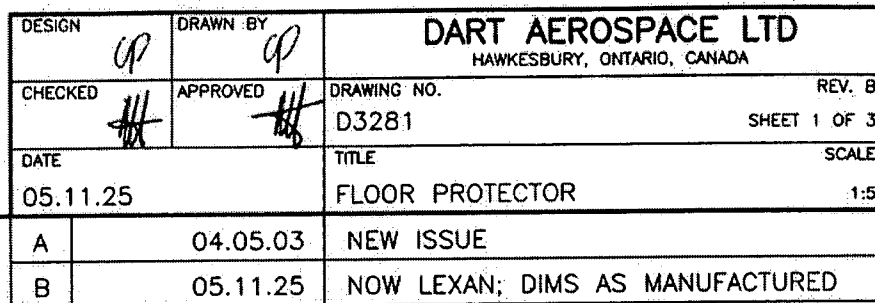
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



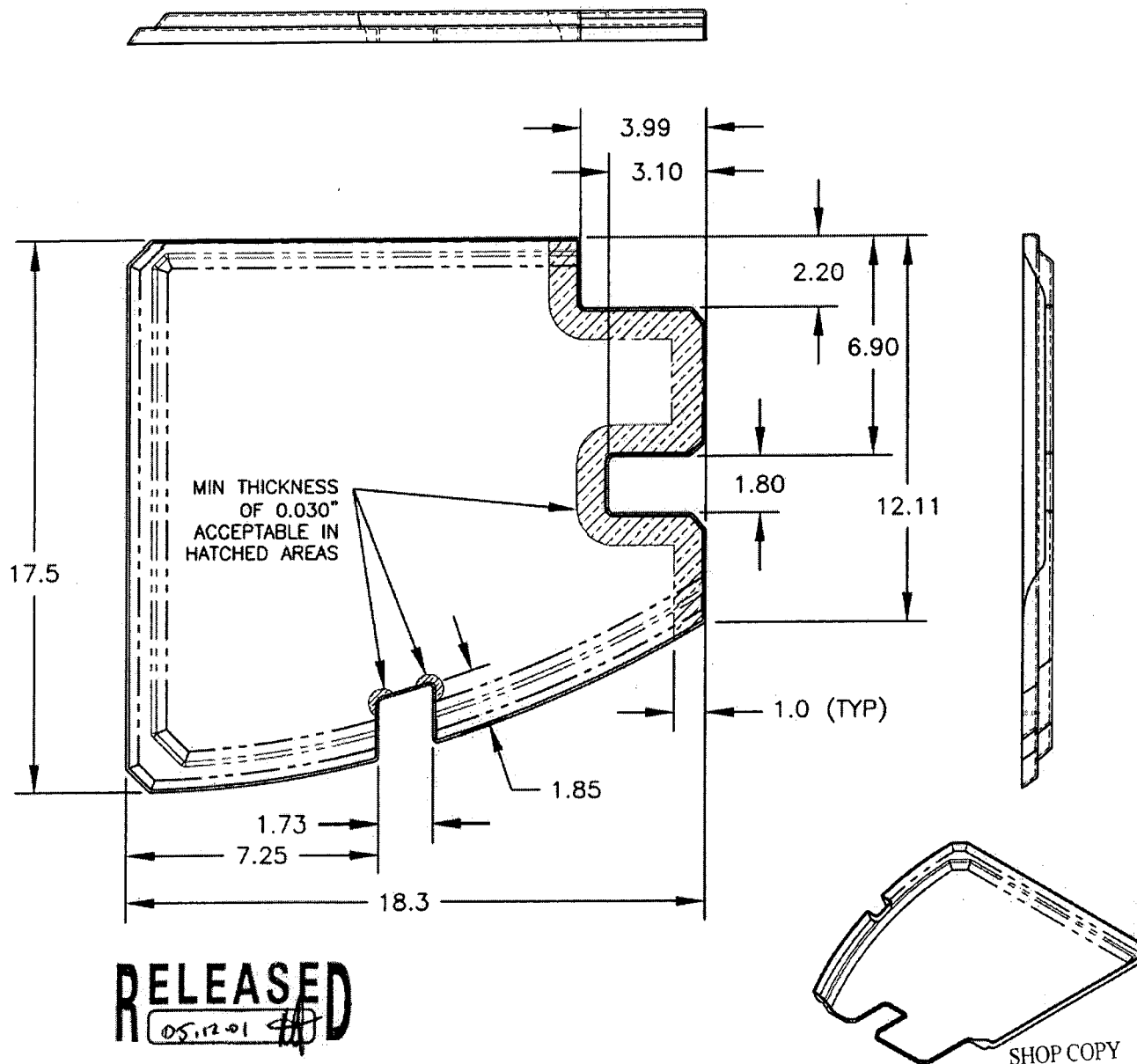
1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK UNCL
3) ALL DIMENSIONS ARE IN INCHES SUB.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

SHOP COPY
RETURN TO
-1T2 ENGINEERING
UNCONTROLLED COPY
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WITHOUT NOTICE
WORK ORDER
NO. 27510

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

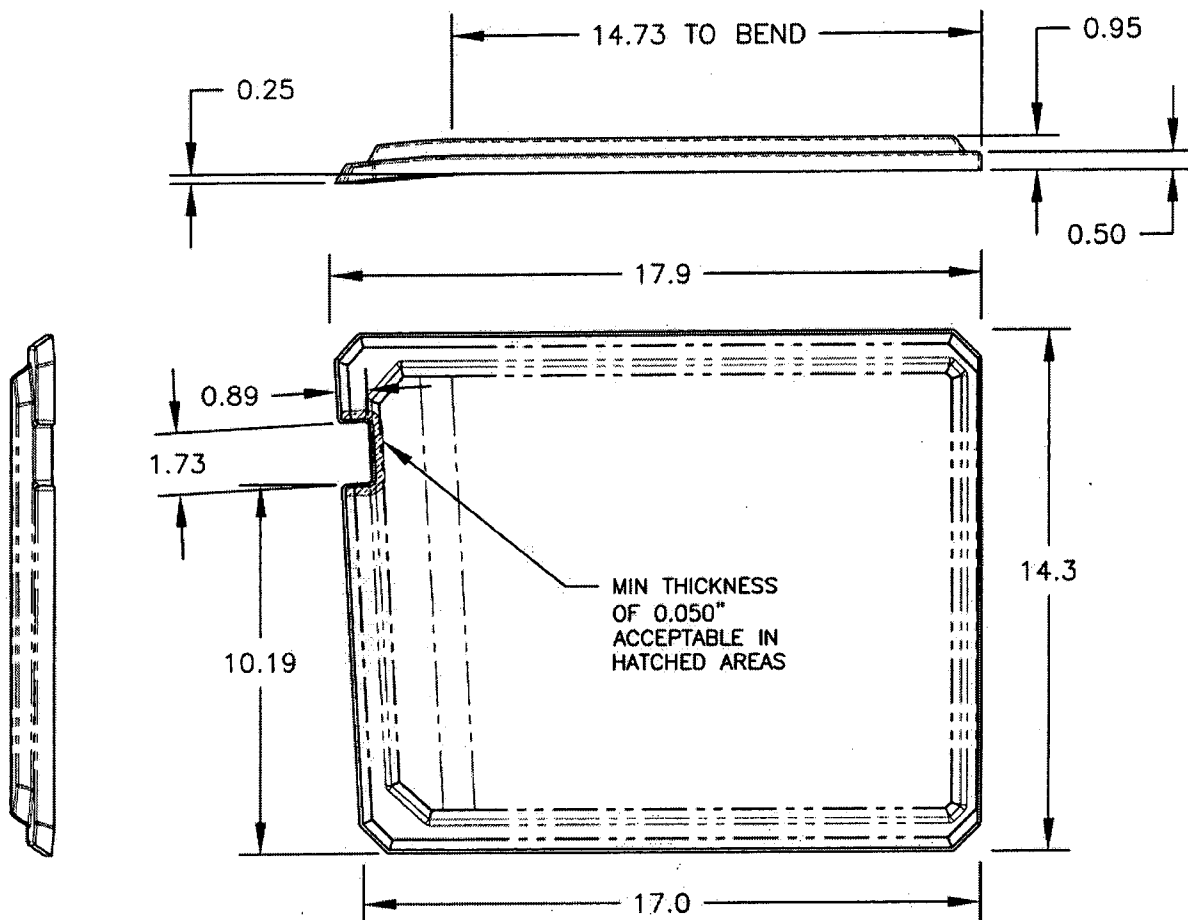
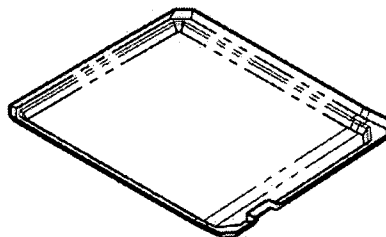
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CHECKED <i>HL</i>	APPROVED <i>HL</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**RELEASED**
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WORK ORDER
NO. 27510**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	10761
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
13/07/06	15/06/06	4716	C. Lavoie	PO00001493			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	0	20	DKC134-0046	Floor Protect Part 3 N° D3281-3 (F6006) Selon dessin D3281 Rev.: B JOB: 36894 QTÉ: 20 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357

ent : DART Dart Aerospace Ltd.
méro, Job : 36894
méro Soumission : 2385
méro B.A. :
te fois : 2006-06-22 No. B.V. :
ht Rev. : NC
m. fois : - - Type :
précédente : 35134

Nom Dessin : FLOOR PROTECTOR AFT, LH
Numéro Article : DKC134-0046
Numéro Dessin : D3281
Projet Numéro : DKC134
Révision dessin : B
Matériel : F6006
Date Dûe : 2006-06-29

Qté: 201 Udm: UNITE

it par :
ifié & Approuvé par :
mmentaires : N° de pièce: D3281-3



Process Sheet Rév.: 01 Inverser le rang de la séquence
d'inspection et d'identification

duit additionnel

méro Job:

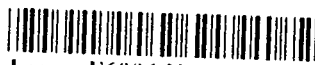


Séq.: Machine ou Opération: Description :

1.0 APL0016 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE/
Lexan F6006 Noir N°

APL0016



1-5327-1

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot:

Bon achat: 5327

2.0 SÉCHAGE/ ANEAL SÉCHAGE / ANEALING



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 5145

3.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 20 Date: 6/5/06 Sceau:

Quantité: Date: Sceau:



Refait
2 pcs de 4



Séq.: Machine ou Opération: Description :


4.0 THERMOFORMAGE2 THERMOFORMAGE DES PIÈCE DART




Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-3 à l'aide du moule N° D3281-3T1 sur le
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 24 Date: 5-7-06 Sceau: 

Quantité: 2 Date: 12-7-06 Sceau: 

5.0 TRIMAGE 3 TRIMAGE COMPOSITES DART





Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-3 à l'aide du gabarit de trimage N° D3281-3T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 24 Date: 16-7-06 Sceau: 

Quantité: 2 Date: 13-7-06 Sceau: SB 

6.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
IDENTIFICATION PIÈCES DART


Faire l'identification des pièces à l'aide des informations suivantes:

N° de pièce: D3281-3

N° de Job: _____

Date de fabrication: _____

Sceau d'inspection.

Quantité: 20 Date: 11-07-06 Sceau: 

Quantité: 2 Date: 13-07-06 Sceau: 



Séq.: Machine ou Opération: Description :

7.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 18 Date: 11-07-06 Sceau:

2 de + 8 B

2rejet # RUC-C1132

8.0 EMBALLAGE 2x 13-07-06 EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en platique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-3

Date de fabrication: _____

N° de job: _____

Quantité: 18 Date: 11/07/06 Sceau:

Quantité: 2 Date: 13/7/06 Sceau: